

Work Order ID 153486

Monday, November 21, 2016 9:23:26 AM

153486

Page 1

Item ID: D3224-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Frame
 Start Date: 11/14/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/21/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: NOV 21 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3224	Rev B						DAS 46 9-89	10/12/21	10/12/21
100	FLOW WATER JET	0.02							
100									
Waterjet	Memo	0.33							
FLOW CNC Waterjet	1-Cut as per Dwg D3224								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00					DAS 46 9-89	10/12/21	
110									
QC	Memo	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Monday, November 21, 2016 9:23:26 AM

153486

N900040100

Setup Start *NS1*

Stop *NS2*

?

Cust Item ID:

Start Date: 11/14/2016 **Start Qty:** 2.00

Required Date: 11/21/2016 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

120

0.01

QC

Memo

Quality Control

DAS
38
9-89
AN 11 2017

NC BRAKE

0.13

140

0.02

Brake NC

Memo

Brake NC

Form as per Dwg D3224

DAS
30
9-89

JAN 12 2017

QC5- Inspect part completeness to step on W/O

0.00

150

0.01

QC

Memo

Quality Control

DAS
 38
 9-89

107 3 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

153486

Monday, November 21, 2016 9:23:27 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Start Date: 11/14/2016 **Start Qty:** 2.00 ***2***

Required Date: 11/21/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : _____					

Work Order ID 153486

Monday, November 21, 2016 9:23:27 AM

153486

Page 4

Item ID: D3224-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Frame

Start Date: 11/14/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/21/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.03							
Quality Control									

17/01/18 *[Signature]*
mf
17-1-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																					

Picklist Print

Monday, November 21, 2016 9:23:26 AM

Page 1

Work Order ID: 153486

153486

Parent Item: D3224-1

D3224-1

Parent Item Name: Frame

Start Date: 11/14/2016

Required Date: 11/21/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

131.1400

5.2

10.94737

DAS
46
9-89

**

16/12/21

M2024T3S 063

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT

24.64

m135512

24.64

MAT009

106.5

m134640

62.1

m135612

44.4

VI

DQA: _____ Date: _____



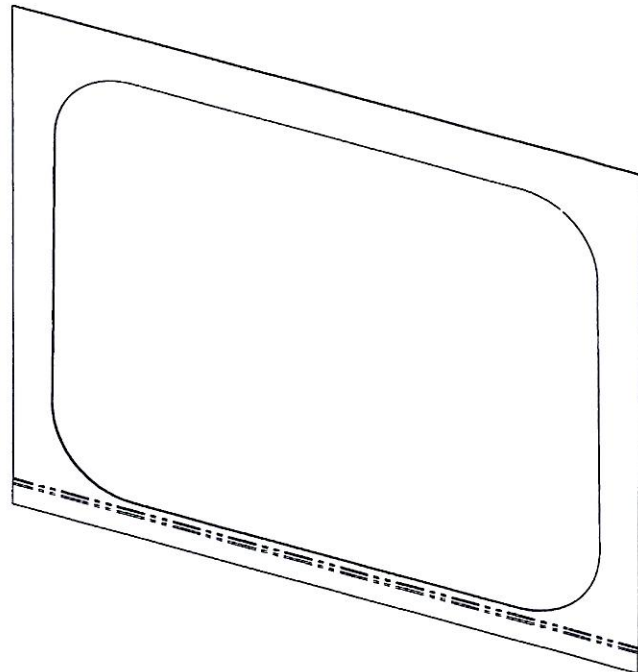
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

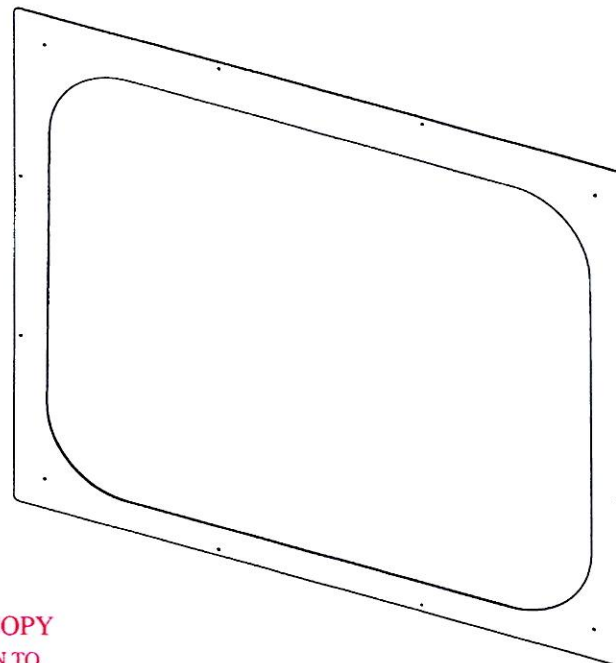
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OTHER : ☐																					

8 7 6 5 4 3 2 1



D3224-1 FRAME



D3224-3 FRAME

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WORK ORDER
NO. 153486 MJS
16-11-21

RELEASED
09/05/13/18

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037
REF. DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3224-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3224-1 = 1.40 lbs
D3224-3 = 1.22 lbs

B	REDRAWN TO CURRENT DRAWING STANDARDS: ADDED D3224-1F AND D3224-3. REASON: SEE NCR#09-054.	MB	09.05.07
A	NEW ISSUE	RF	03.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.05.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3224** REV. B
TITLE **FRAME** SCALE NTS
SHEET 1 OF 3

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